Work Order ID 73339 Page 1 Wednesday, August 31, 2011 11:04:33 AM Item ID: D3405-043 Accept Setup Start **Revision ID:** Stop Lug Assembly Item Name: **Start Qty: 12.00** Start Date: 9/1/2011 **Cust Item ID:** Required Date: 9/15/2011 Req'd Oty: 12.00 **Customer:** Reference: Run Start Process Plan: MF Date: | -09-0 | Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Accept Reject Insp. **Work Center ID** Description Qty Qty **Run Hours** Code Number Stamp Draw Nbr Revision Nbr D3405 Rev B 100 0.00 FLOW WATER JET 1311-9-8 0.00 Waterjet FLOW CNC Waterjet 1-Cut as per Dwg D3405 Dwg Rev: 304.175 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 B1-9-8 0.00 Memo Quality Control 120 QC8- Inspect parts - second check Memo 

Quality Control

Dart	<b>Aeros</b>	pace	Ltd
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W/O:			W	ORK ORDER CHANGE	S			
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No <b>DQA</b> :	Date: _	
	R	esolution:	_ Disposit	ion:	QA: N/C Cld	sed:	Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR	)		
DATE	STEP	Description of NC		Corrective Action Section		Verification Section C	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng			Chief Eng	QC Inspector
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#### Work Order ID 73339

Wednesday, August 31, 2011 11:04:33 AM



Page 2

Item ID:

D3405-043

Accept



Setup Start



**Revision ID:** 

Item Name: Lug Assembly

Required Date: 9/15/2011

9/1/2011

Start Oty: 12.00 Req'd Qty: 12.00

**Cust Item ID:** Customer:

Stop

Start

Reference:

Start Date:

Approvals:

Process Plan:

Date: \_\_\_\_\_ Tooling:

0.00

0.00

Date:

Stop

Run



Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Tool ID

Tool # Plan

Code

Accept Qty

Reject Oty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

130

Brake NC Brake NC

Operation **Description** 

NC BRAKE

Memo 1-Deburr

2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming

0.00 JB uloal12

140

Quality Control

QC5- Inspect part completeness to step on W/O

113

Memo

150

Large Fab Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-043

Weld per dwg A/R S.S. rod Batch: M117659

R 1/9-14

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W/O:			W	ORK ORDER CHANG	ES					
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	R	esolution:	Disposition	on:	_ QA: N/C	Clos	ed:		Date: _	·
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (N	CR)				
DATE	OTED	Description of NC		ection B Ve			ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Section C		Chief Eng	QC Inspector
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#### Work Order ID 73339

Wednesday, August 31, 2011 11:04:33 AM



Page 3

Item ID:

D3405-043

Accept

Setup Start

Stop

**Revision ID:** 

Item Name:

Lug Assembly

Start Date: Required Date: 9/15/2011

9/1/2011

**Start Oty: 12.00** 

Reg'd Oty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

QC:

Date: \_\_\_\_

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

160

QC

Quality Control

**Operation** Description

QC9- Inspect visual per OSI004- Fusion Welds

Memo

Memo

Set Up/ Run Hours

0.00

PC 11.05.14

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sul 14

180



Powder Coating

M118439

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: OVEN TEMPERATURE: FINISH TIME:

15x & M.f. 11/09/15

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W/O:		and the state of t	W	ORK ORDER CHANGES					
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Part No: PAR		PAR #:	Fault Cate	gory: N	ICR: Yes	No <b>DQ</b>	A:	Date: _	·
Resolution:									
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DATE	STEP	Description of NC	Description of NC Corrective Action Section			Verific	cation	Approval	Approval
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#### Work Order ID 73339

Wednesday, August 31, 2011 11:04:33 AM



Page 4

Item ID:

D3405-043

Accept

Tool # Plan

Code

Setup Start



**Revision ID:** 

Item Name: **Start Date:** 

Lug Assembly

9/1/2011

QC:

**Start Qty: 12.00** Req'd Qty: 12.00

Date:

**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

**Approvals:** 

Required Date: 9/15/2011

Process Plan:

Date: \_\_\_\_

Tooling:

SPC (Y/N):

Date: Date: Run

Reject

Qty

Start

Stop

Stop



Sequence ID/

**Work Center ID** 

190

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Accept

Qty

Insp.

Stamp

200

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Reject

Number

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W (1-09-16

W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NC	7)			4 - 10 - 10 - 10 - 10 - 10 - 10 - 10 - 1
DATE	CTED	Description of NC Corrective Action Section B				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Chief Eng	QC Inspector
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### **Picklist Print**

Wednesday, August 31, 2011 11:04:30 AM

Work Order ID: 73339

Parent Item: D3405-043

Parent Item Name: Lug Assembly



**Start Date:** 9/1/2011

Required Date: 9/15/2011

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

**Comments:** 

IPP A□05.09.01□New issue□KJ/JLM□

IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No	. /		100	Each	50.0000	1	12 <i>E</i> Z	16	9-14	ı
		No more	sfo	Location WA WA030	70664	Loc	Oty 7 7 43 43	Loc Code	- - -	16	- - -		
M304S11GA 304/316 0.125 Sheet		Purchased	No		12320	150	sf	43.5000	0.154	1.945263	1-q-8	-	
				Location MAT020			<u>Qtv</u> 43.5 43.5	Loc Code	<u></u>	17 494	-	(K)	)

Dart Aerospace	Lta
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W/O:			WC	RK ORDER CHANG	ES				
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Part No		PAR #:							
	R	esolution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)			
DATE	OTED	Description of NC			on B	Verification A		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	k Sect	ion C	Chief Eng	QC Inspector
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		,							

DART AEROSPACE LTD	Work Order:	73339
Description: GHW Bracket	Part Number:	D3405-3
Inspection Dwg: D3405 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.439	>		V BOZ	
1.50	+/-0.030	1.503	9		V	
1.750	+/-0.010	1747	>		V	
R0.63	+/-0.030	.63	1		RG.	
3.00	+/-0.030	3,003	7		V	
8.00	+/-0.030	8.003	>		V	
6.751	+/-0.005	6.753	9		1/	
					<b>V</b>	
						·
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Measured by: B	Audited by:	Prototype Approval:	N/A
Date: 11-9-8	Date: 1169/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue P/O D3405-043	KJ/JLM ,	11
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD #	Just

W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PROC	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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						-			
Part No	<b>:</b>	PAR #:	_ Fault Categ	jory:	NCR: Yes	No DQ	<b>A</b> :	Date:	-
	R	esolution:	_ Disposition	:	QA: N/C Cld	sed:		Date:	· · · · · · · · · · · · · · · · · · ·
NCR:	,	W	ORK ORDE	R NON-CONFORMA	NCE (NCR	)			
		Description of NC	Corrective Action Section			Verific	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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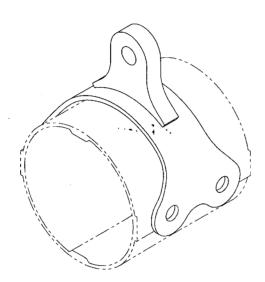
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ITEM No. QTY. -041 QTY. -043 PART NUMBER DESCRIPTION Х D3405-041 LUG ASSEMBLY D3405-043 LUG ASSEMBLY х 2 D3404-1 GHW LUG 11 1

D3405-1

D3405-3

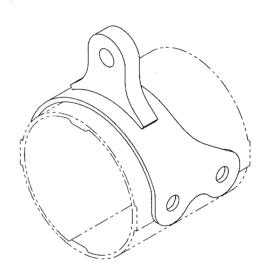




GHW BRACKET

GHW BRACKET

D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

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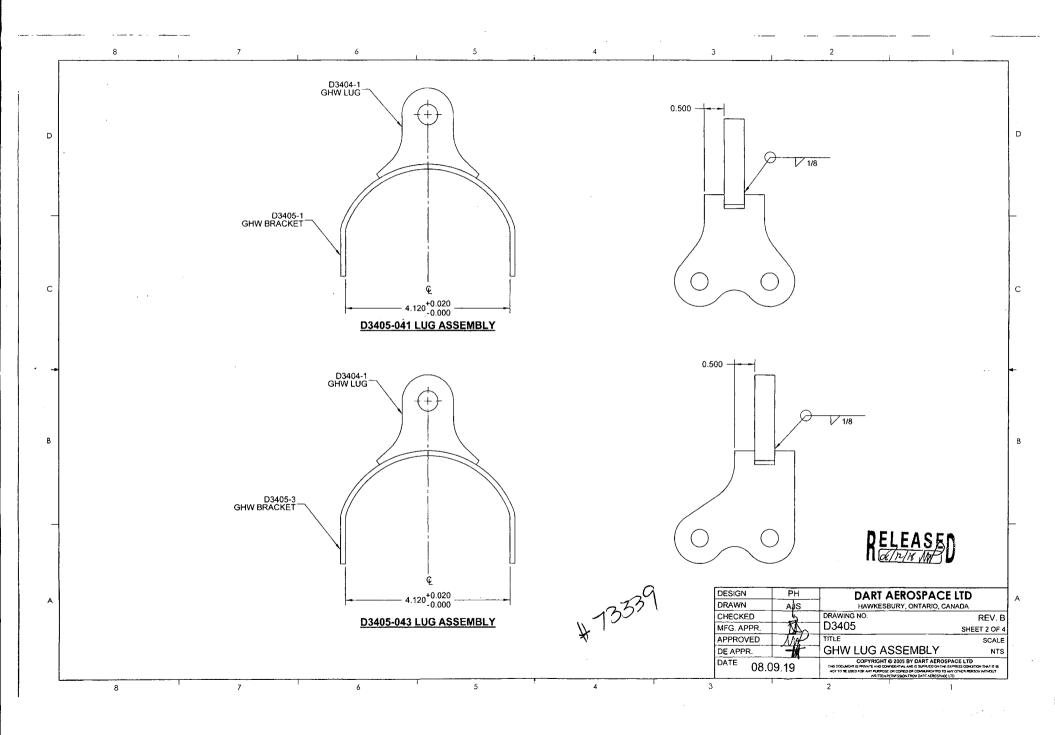
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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

В	STANDA FLAT PA PREVEN ZONE A	ATTERN NT FOU	AJS	08.09.19		
Α	NEW IS:	SUE	PH	05.03.08		
REV.			BY	DATE		
DESIGN	SIGN PH DART AEROSPA					TD
DRAWN		A.	S	HAWKESBURY, ONTARI	O, CANA	ADA
CHECK	ED	لور	<u>.                                    </u>	DRAWING NO.		REV. B
MFG. A	PPR.		$\Omega$	D3405		SHEET 1 OF 4
APPRO	VED	Jim	$\mathcal{P}$	TITLE		SCALE
DE APPR GHW I			] GHW LUG ASSEMBL	Y	NTS	
DATE 08.09.19				COPYRIGHT © 2005 BY DART A THIS DOCUMENT IS PRIVATE AND COMPOSITION AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICO WHETTEN REBINISSOM PROMIDANT ASS	ON THE EXPRE	SS CONDITION THAT IT IS

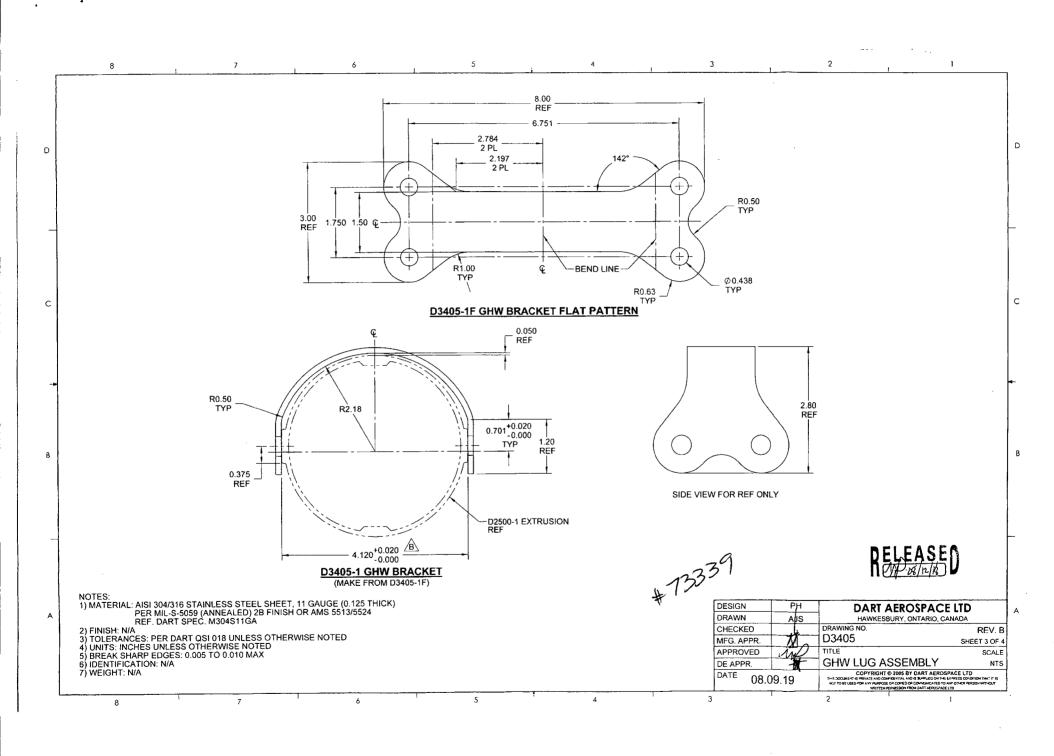
DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT

#### **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: **Approval Approval** By Qty STEP PROCEDURE CHANGE Date DATE Chief Eng / QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval STEP DATE** Sign & Initial **Action Description** QC Inspector Section A Section C Chief Eng Chief Eng Chief Eng Date



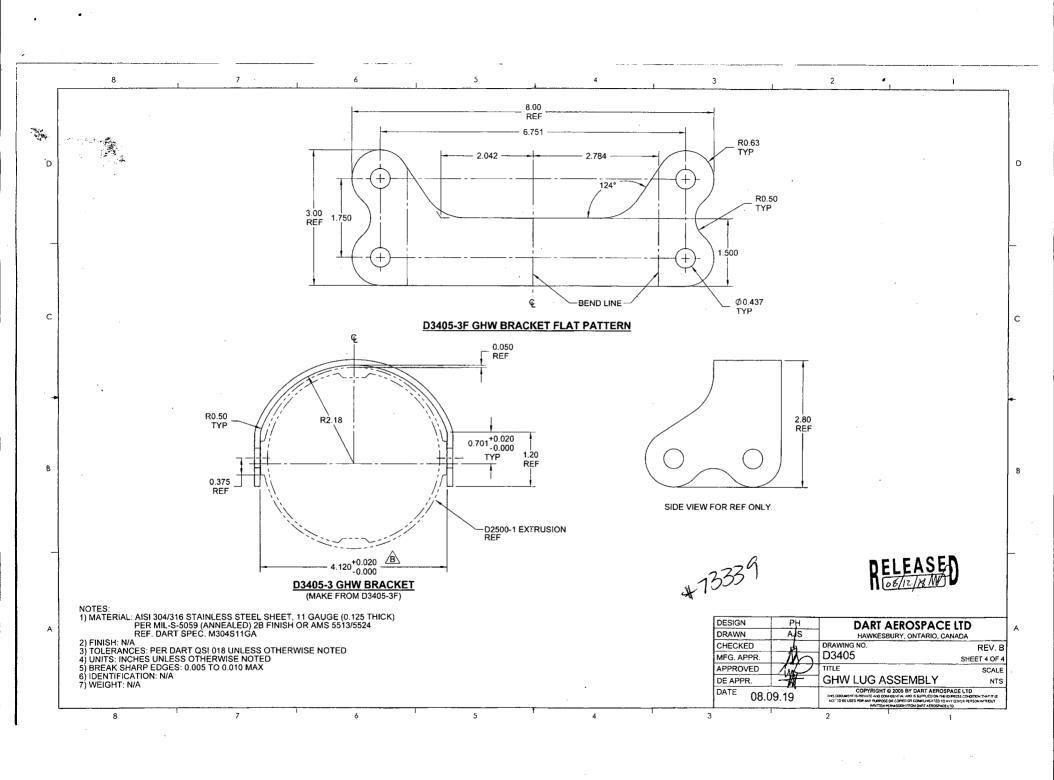
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Part No	):	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _	***************************************

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NCR:		<i>(</i>	WORK ORDER NON-CONFORMANCE (NCR)					
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W/O: WORK ORDER CHANGES  DATE STEP PROCEDURE CHANGE By Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No: PAR #: Fault Category: NCR: Yes No D						
Resolution: Disposition: QA: N/C Closed: _						
NCR: WORK ORDER NON-CONFORMANCE (NCR)	IANCE (NCR)					
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